# Section 1. Registration Information

## Source Identification

| | |
|---|---|
| Facility Name: | Flavor Right Foods Group, Inc. |
| Parent Company #1 Name: | |
| Parent Company #2 Name: | |

## Submission and Acceptance

| | |
|---|---|
| Submission Type: | First-time submission |
| Subsequent RMP Submission Reason: | |
| Description: | |
| Receipt Date: | 13-Oct-2010 |
| Postmark Date: | 13-Oct-2010 |
| Next Due Date: | 13-Oct-2015 |
| Completeness Check Date: | 13-Oct-2010 |
| Complete RMP: | Yes |
| De-Registration / Closed Reason: | |
| De-Registration / Closed Reason Other Text: | |
| De-Registered / Closed Date: | |
| De-Registered / Closed Effective Date: | |
| Certification Received: | Yes |

## Facility Identification

| | |
|---|---|
| EPA Facility Identifier: | 1000 0021 2478 |
| Other EPA Systems Facility ID: | |

## Dun and Bradstreet Numbers (DUNS)

| | |
|---|---|
| Facility DUNS: | 35907658 |
| Parent Company #1 DUNS: | |
| Parent Company #2 DUNS: | |

## Facility Location Address

| | |
|---|---|
| Street 1: | 1910 W Mountain View Rd. |
| Street 2: | |
| City: | Phoenix |
| State: | ARIZONA |
| ZIP: | 85021 |
| ZIP4: | |
| County: | MARICOPA |

## Facility Latitude and Longitude

| | |
|---|---|
| Latitude (decimal): | 33.343139 |
| Longitude (decimal): | -112.060527 |
| Lat/Long Method: | GPS - Unspecified |
| Lat/Long Description: | Air Release Vent |
| Horizontal Accuracy Measure: | 10 |
| Horizontal Reference Datum Name: | North American Datum of 1983 |
| Source Map Scale Number: | |

## Owner or Operator

| | |
|---|---|
| Operator Name: | Flavor Right Foods Group, Inc. |
| Operator Phone: | (602) 232-2570 |

## Mailing Address

| | |
|---|---|
| Operator Street 1: | 2517 East Chambers Street |
| Operator Street 2: | |
| Operator City: | Phoenix |
| Operator State: | ARIZONA |
| Operator ZIP: | 85040 |
| Operator ZIP4: | |
| Operator Foreign State or Province: | |
| Operator Foreign ZIP: | |
| Operator Foreign Country: | |

## Name and title of person or position responsible for Part 68 (RMP) Implementation

| | |
|---|---|
| RMP Name of Person: | Calvin R. Warf |
| RMP Title of Person or Position: | Vice President |
| RMP E-mail Address: | rwarf@flavorrightfoods.com |

## Emergency Contact

| | |
|---|---|
| Emergency Contact Name: | Ryan Davis |
| Emergency Contact Title: | Maintenance Supervisor |
| Emergency Contact Phone: | (602) 232-2570 |
| Emergency Contact 24-Hour Phone: | (520) 483-3946 |
| Emergency Contact Ext. or PIN: | |
| Emergency Contact E-mail Address: | rdavis@flavorrightfoods.com |

## Other Points of Contact

| | |
|---|---|
| Facility or Parent Company E-mail Address: | |
| Facility Public Contact Phone: | (602) 997-1267 |
| Facility or Parent Company WWW Homepage Address: | |

## Local Emergency Planning Committee

| | |
|---|---|
| LEPC: | Maricopa County LEPC |

## Full Time Equivalent Employees

| | |
|---|---|
| Number of Full Time Employees (FTE) on Site: | 4 |
| FTE Claimed as CBI: | |

## Covered By

| | |
|---|---|
| OSHA PSM : | Yes |
| EPCRA 302 : | Yes |
| CAA Title V: | |
| Air Operating Permit ID: | |

## OSHA Ranking

OSHA Star or Merit Ranking:

## Last Safety Inspection

| | |
|---|---|
| Last Safety Inspection (By an External Agency) Date: | 08-Sep-2010 |
| Last Safety Inspection Performed By an External Agency: | Fire Department |

## Predictive Filing

Did this RMP involve predictive filing?:

## Preparer Information

| | |
|---|---|
| Preparer Name: | Jason E. Krantz |
| Preparer Phone: | (480) 748-1574 |
| Preparer Street 1: | 2517 East Chambers Street |
| Preparer Street 2: | |
| Preparer City: | Phoenix |
| Preparer State: | ARIZONA |
| Preparer ZIP: | 85040 |
| Preparer ZIP4: | |
| Preparer Foreign State: | |
| Preparer Foreign Country: | |
| Preparer Foreign ZIP: | |

## Confidential Business Information (CBI)

CBI Claimed:
Substantiation Provided:
Unsanitized RMP Provided:

## Reportable Accidents

| | |
|---|---|
| Reportable Accidents: | See Section 6. Accident History below to determine if there were any accidents reported for this RMP. |

## Process Chemicals

| | |
|---|---|
| Process ID: | 1000019967 |
| Description: | Ammonia Refrigeration |
| Process Chemical ID: | 1000024350 |
| Program Level: | Program Level 3 process |
| Chemical Name: | Ammonia (anhydrous) |
| CAS Number: | 7664-41-7 |
| Quantity (lbs): | 13500 |
| CBI Claimed: | |
| Flammable/Toxic: | Toxic |

## Process NAICS

| | |
|---|---|
| Process ID: | 1000019967 |
| Process NAICS ID: | 1000020336 |
| Program Level: | Program Level 3 process |
| NAICS Code: | 31193 |
| NAICS Description: | Flavoring Syrup and Concentrate Manufacturing |

# Section 2. Toxics: Worst Case

## Toxic Worst ID: 1000016915

| | |
|---|---|
| Percent Weight: | 100.0 |
| Physical State: | Gas liquified by pressure |
| Model Used: | EPA's RMP*Comp(TM) |
| Release Duration (mins): | 10 |
| Wind Speed (m/sec): | 1.5 |
| Atmospheric Stability Class: | F |
| Topography: | Urban |

### Passive Mitigation Considered

| | |
|---|---|
| Dikes: | |
| Enclosures: | Yes |
| Berms: | |
| Drains: | |
| Sumps: | |
| Other Type: | |

# Section 3. Toxics: Alternative Release

## Toxic Alter ID: 1000018464

| | |
|---|---|
| Percent Weight: | 100.0 |
| Physical State: | Gas liquified by pressure |
| Model Used: | EPA's RMP*Comp(TM) |
| Wind Speed (m/sec): | 3.0 |
| Atmospheric Stability Class: | D |
| Topography: | Urban |

### Passive Mitigation Considered

| | |
|---|---|
| Dikes: | |
| Enclosures: | Yes |
| Berms: | |
| Drains: | |
| Sumps: | |
| Other Type: | |

### Active Mitigation Considered

| | |
|---|---|
| Sprinkler System: | |
| Deluge System: | |
| Water Curtain: | |
| Neutralization: | |
| Excess Flow Valve: | |
| Flares: | |
| Scrubbers: | |
| Emergency Shutdown: | Yes |
| Other Type: | |

# Section 4. Flammables: Worst Case

No records found.

# Section 5. Flammables: Alternative Release

No records found.

# Section 6. Accident History

No records found.

# Section 7. Program Level 3

## Description

Ammonia Refrigeration System Â¿ General Prevention

General Safety

Flavor Right helps prevent releases from the Ammonia Refrigeration System through general safety as follows:
Â¿ Gauges and valves installed at all vessels, equipment, and controls.
Â¿ All accumulators and intercoolers equipped with high level float switches that sound a high liquid alarm level and shut down compressors when high liquid level detected.
Â¿ Main liquid king valve shut off valves are prominently identified with signs.
Â¿ Oil drain valves are self-closing.
Â¿ There is signage at the Ammonia Refrigeration Building prominently displaying:
o Name, address and telephone of installing and servicing contractor
o Approximate quantity of ammonia
o Lubricant type and amount
o Field test pressure
o Emergency instructions, emergency phone numbers, and emergency contacts
Â¿ Ammonia Refrigeration Building floor is free of oil, grease, and water.
Â¿ Aisles in the Ammonia Refrigeration Building are clear of obstructions.
Â¿ Personnel can exit quickly and safely in the event of a leak.
Â¿ There is more than one exit from the Ammonia Refrigeration Building to the outdoors.
Â¿ The exits are clear of piping and other obstructions.
Â¿ The ammonia refrigeration system is currently free of leaks.
Â¿ The ammonia refrigeration system is free of abnormal sounds, vibrations, and pulsations.
Â¿ There is an emergency shower and eyewash available.
Â¿ There are covers securely fastened to all electrical panels and junction boxes.
Â¿ A maintenance and repair log, including oil management maintained.
Â¿ A thorough formal inspection of the ammonia refrigeration system by a competent professional engineer specializing in ammonia refrigeration systems completed.
Â¿ Several thorough formal inspections of the ammonia refrigeration system by the local fire department completed.
Â¿ Ammonia Refrigeration Building and Mezzanine is secure and access is restricted to authorized personnel.
Â¿ Vent lines from pressure relief valve s extend to a large water diffusion tank.

General Comments

The ammonia refrigeration system received updates in accordance with current codes and standards in 2010. The local fire department conducted several inspections during the 2010 update process to ensure the company engineered appropriate safeguards into the system. A professional engineer specializing in ammonia refrigeration systems completed a complete mechanical integrity study on the ammonia refrigeration system.
New instrumentation controls and monitors the ammonia refrigeration system. The company updated the ammonia refrigeration system with ammonia detection systems, including visual/audible alarms. All equipment pressure-relief valves are new installed 2010. The company utilizes a continuous flow ventilation fan. Emergency exhaust ventilation is available for emergency events. Process equipment operates within design limits and is in good clean condition. There is not excessive dirt, scale, or ice built up around the system. The company secured equipment so it does not exhibit excessive vibration.
Administrative controls as described below are in place to help prevent and mitigate releases.

Ammonia Refrigeration System - Equipment General Prevention

Ammonia Detection System (2010 Installation)
Â¿ Main Instrumentation Panel in Control Room of Ammonia Refrigeration Building
Â¿ Ammonia Sensors
o Ammonia Refrigeration Building: Machine Room; South Wall

o Ammonia Refrigeration Building: Machine Room; Vent Lines
o Warehouse Building: Cooler Area
o Warehouse Building: Freezer Area
o Warehouse Building: Dock
Â¿ Detection Levels
o 25 ppm in Warehouse
o 50 ppm in Machine Room
Â¿ Detection Activators
o Warehouse: 25 ppm activates visual and audible alarms, and shuts off liquid to the affected zone area
o Machine Room: 50 ppm activates visual and audible alarms, and activates the vertical stack emergency ventilation roof fan
o Machine Room: 300 ppm shuts down all Machine Room equipment, and activates a alarm condition with the local fire department

Visual / Audible Alarm System (2010 Installation)
Â¿ Warehouse: Exterior Dock
Â¿ Warehouse: Interior Dock
Â¿ Warehouse: Freezer
Â¿ Warehouse: Staging
Â¿ Warehouse: Cooler
Â¿ Ammonia Refrigeration Building: Exterior; Southwest Corner
Â¿ Ammonia Refrigeration Building: Exterior; Northwest Corner
Â¿ Ammonia Refrigeration Building: Exterior; Outside of Control Room

Pressure Relief Valves
Â¿ Are replaced new in 2010
Â¿ Are suitable for ammonia
Â¿ Have proper relief setting
Â¿ Have required discharge capacity
Â¿ Have unbroken ASME seal
Â¿ Are installed per ANSI/IIAR-2
Â¿ Are connected above the liquid levels
Â¿ Include inlet piping conforming to ANSI/IIAR-2
Â¿ Include discharge piping conforming to ANSI/IIAR-2
Â¿ Are piped to vent lines ending at a large water diffusion tank
Â¿ Are located out of refrigerated spaces
Â¿ DO NOT have stop valves installed in the pressure-relief inlets and outlets

Ventilation
Â¿ Continuous Flow Ventilation Fan at 2,000 CFM: Rooftop Vertical Exhaust
Â¿ Emergency Flow Ventilation Fan at 14,500 CFM: Rooftop Vertical Exhaust
Â¿ Emergency Fan Control Panel - Ammonia Refrigeration Building: Exterior; Northwest Corner

Ammonia Refrigeration System - Equipment Specific Prevention

Compressors
Â¿ Are suitable for ammonia
Â¿ Operate within design limits
Â¿ Are adequately anchored and supported
Â¿ Have safe access for service and maintenance
Â¿ Are free from excessive vibration

Evaporative Condensers
Â¿ Are clean with no corrosion
Â¿ Are suitable for ammonia
Â¿ Operate within design limits

Â¿ Are adequately anchored and supported
Â¿ Are free from excess, visible vibration
Â¿ Are adequately protected against traffic hazards
Â¿ Have purge valves in good condition
Â¿ Have auto refrigerated air purge installed
Â¿ Have condenser isolation valves in good condition
Â¿ Are without dust and scale buildup on the condenser coil, mist eliminators, and water sump
Â¿ Have water distributors that operate effectively
Â¿ Have mist eliminators that operate effectively

Air-Cooling Evaporators
Â¿ Are clean with no visible corrosion
Â¿ Are suitable for ammonia
Â¿ Operate within design limits
Â¿ Are adequately anchored and supported
Â¿ Are free from excessive vibration
Â¿ Is free of excessive ice buildup and clean of dirt
Â¿ Have drives properly guarded and protected

Piping
Â¿ Is adequately supported
Â¿ Is free of abnormal ice formations
Â¿ Have ammonia drain valves fitted with plugs
Â¿ Have gauge valves and gauges installed at control valves
Â¿ Have gauges in good working order
Â¿ Is marked in accordance with IIAR Bulletin 114
Â¿ Is installed in accordance with IIAR-2-1992 Section 5
Â¿ Have mechanical fasteners tight

Pressure Vessels
Â¿ Are operating within pressure and temperature limitations
Â¿ Are with ASME stamp visible
Â¿ Have manufacturer data reports on file
Â¿ Are without known alterations or modifications
Â¿ Have relief valves as indicated in the pressure relief valve section
Â¿ Are marked in accordance with IIAR Bulletin 114
Â¿ Without visible corrosion on pressure relief valves

Ammonia Refrigeration System - Administrative Prevention

Process Safety Management
Flavor Right developed a process safety management program for the ammonia refrigeration system. The process safety management program complies with the Occupational Safety and Health Administration (OSHA) Process Safety Management for Highly Hazardous Materials standard.

Operating Procedures
Operating procedures exist for the ammonia refrigeration system and applicable maintenance activities. A licensed refrigeration contractor familiar with ammonia refrigeration system provides 24-hour service and guidance.

## Program Level 3 Prevention Program Chemicals

| | |
|---|---|
| Prevention Program Chemical ID: | 1000020422 |
| Chemical Name: | Ammonia (anhydrous) |

| | |
|---|---|
| Flammable/Toxic: | Toxic |
| CAS Number: | 7664-41-7 |
| Prevention Program Level 3 ID: | 1000016758 |
| NAICS Code: | 31193 |

## Safety Information

| | |
|---|---|
| Safety Review Date (The date on which the safety information was last reviewed or revised): | 30-Sep-2010 |

## Process Hazard Analysis (PHA)

| | |
|---|---|
| PHA Completion Date (Date of last PHA or PHA update): | 04-Aug-2010 |

## The Technique Used

| | |
|---|---|
| What If: | Yes |
| Checklist: | |
| What If/Checklist: | |
| HAZOP: | |
| Failure Mode and Effects Analysis: | |
| Fault Tree Analysis: | |
| Other Technique Used: | |
| PHA Change Completion Date (The expected or actual date of completion of all changes resulting from last PHA or PHA update): | |

## Major Hazards Identified

| | |
|---|---|
| Toxic Release: | Yes |
| Fire: | |
| Explosion: | |
| Runaway Reaction: | |
| Polymerization: | |
| Overpressurization: | Yes |
| Corrosion: | Yes |
| Overfilling: | Yes |
| Contamination: | |
| Equipment Failure: | Yes |
| Loss of Cooling, Heating, Electricity, Instrument Air: | Yes |
| Earthquake: | |
| Floods (Flood Plain): | |
| Tornado: | |
| Hurricanes: | |
| Other Major Hazard Identified: | |

## Process Controls in Use

| | |
|---|---|
| Vents: | Yes |
| Relief Valves: | Yes |
| Check Valves: | Yes |
| Scrubbers: | |
| Flares: | |

| | |
|---|---|
| Manual Shutoffs: | Yes |
| Automatic Shutoffs: | Yes |
| Interlocks: | Yes |
| Alarms and Procedures: | Yes |
| Keyed Bypass: | |
| Emergency Air Supply: | |
| Emergency Power: | Yes |
| Backup Pump: | |
| Grounding Equipment: | |
| Inhibitor Addition: | |
| Rupture Disks: | |
| Excess Flow Device: | |
| Quench System: | |
| Purge System: | |
| None: | |
| Other Process Control in Use: | Diffusion Tank with Water |

## Mitigation Systems in Use

| | |
|---|---|
| Sprinkler System: | |
| Dikes: | |
| Fire Walls: | |
| Blast Walls: | |
| Deluge System: | |
| Water Curtain: | |
| Enclosure: | Yes |
| Neutralization: | |
| None: | |
| Other Mitigation System in Use: | Continuous Flow Exhaust Fan, Emergency Flow Exhaust Fan |

## Monitoring/Detection Systems in Use

| | |
|---|---|
| Process Area Detectors: | Yes |
| Perimeter Monitors: | |
| None: | |
| Other Monitoring/Detection System in Use: | |

## Changes Since Last PHA Update

| | |
|---|---|
| Reduction in Chemical Inventory: | |
| Increase in Chemical Inventory: | |
| Change Process Parameters: | |
| Installation of Process Controls: | Yes |
| Installation of Process Detection Systems: | |
| Installation of Perimeter Monitoring Systems: | |
| Installation of Mitigation Systems: | |
| None Recommended: | |
| None: | |
| Other Changes Since Last PHA or PHA Update: | Installed pipe supports on piping at bottom of vessels to prevent damage resulting in a release |

## Review of Operating Procedures

| | |
|---|---|
| Operating Procedures Revision Date (The date of the most recent review or revision of operating procedures): | 30-Sep-2010 |

## Training

| | |
|---|---|
| Training Revision Date (The date of the most recent review or revision of training programs): | 30-Sep-2010 |

## The Type of Training Provided

| | |
|---|---|
| Classroom: | Yes |
| On the Job: | Yes |
| Other Training: | |

## The Type of Competency Testing Used

| | |
|---|---|
| Written Tests: | Yes |
| Oral Tests: | Yes |
| Demonstration: | Yes |
| Observation: | Yes |
| Other Type of Competency Testing Used: | |

## Maintenance

| | |
|---|---|
| Maintenance Procedures Revision Date (The date of the most recent review or revision of maintenance procedures): | 30-Sep-2010 |
| Equipment Inspection Date (The date of the most recent equipment inspection or test): | 30-Aug-2010 |
| Equipment Tested (Equipment most recently inspected or tested): | Mechanical integrity inspection and report completed on entire system |

## Management of Change

| | |
|---|---|
| Change Management Date (The date of the most recent change that triggered management of change procedures): | |
| Change Management Revision Date (The date of the most recent review or revision of management of change procedures): | 30-Sep-2010 |

## Pre-Startup Review

| | |
|---|---|
| Pre-Startup Review Date (The date of the most recent pre-startup review): | 09-Aug-2010 |

## Compliance Audits

| | |
|---|---|
| Compliance Audit Date (The date of the most recent compliance audit): | |

| | |
|---|---|
| Compliance Audit Change Completion Date (Expected or actual date of completion of all changes resulting from the compliance audit): | |

## Incident Investigation

| | |
|---|---|
| Incident Investigation Date (The date of the most recent incident investigation (if any)): | |
| Incident Investigation Change Date (The expected or actual date of completion of all changes resulting from the investigation): | |

## Employee Participation Plans

| | |
|---|---|
| Participation Plan Revision Date (The date of the most recent review or revision of employee participation plans): | 30-Sep-2010 |

## Hot Work Permit Procedures

| | |
|---|---|
| Hot Work permit Review Date (The date of the most recent review or revision of hot work permit procedures): | 30-Sep-2010 |

## Contractor Safety Procedures

| | |
|---|---|
| Contractor Safety Procedures Review Date (The date of the most recent review or revision of contractor safety procedures): | 30-Sep-2010 |
| Contractor Safety Performance Evaluation Date (The date of the most recent review or revision of contractor safety performance): | |

## Confidential Business Information

| | |
|---|---|
| CBI Claimed: | |

# Section 8. Program Level 2

# Section 9. Emergency Response

## Written Emergency Response (ER) Plan

| | |
|---|---|
| Community Plan (Is facility included in written community emergency response plan?): | |
| Facility Plan (Does facility have its own written emergency response plan?): | Yes |
| Response Actions (Does ER plan include specific actions to be taken in response to accidental releases of regulated substance(s)?): | Yes |
| Public Information (Does ER plan include procedures for informing the public and local agencies responding to accidental release?): | Yes |
| Healthcare (Does facility's ER plan include information on emergency health care?): | Yes |

## Emergency Response Review

| | |
|---|---|
| Review Date (Date of most recent review or update of facility's ER plan): | 30-Sep-2010 |

## Emergency Response Training

| | |
|---|---|
| Training Date (Date of most recent review or update of facility's employees): | 09-Aug-2010 |

## Local Agency

| | |
|---|---|
| Agency Name (Name of local agency with which the facility ER plan or response activities are coordinated): | Phoenix Fire Department |
| Agency Phone Number (Phone number of local agency with which the facility ER plan or response activities are coordinated): | (602) 262-6297 |

## Subject to

| | |
|---|---|
| OSHA Regulations at 29 CFR 1910.38: | Yes |
| OSHA Regulations at 29 CFR 1910.120: | Yes |
| Clean Water Regulations at 40 CFR 112: | |
| RCRA Regulations at CFR 264, 265, and 279.52: | |
| OPA 90 Regulations at 40 CFR 112, 33 CFR 154, 49 CFR 194, or 30 CFR 254: | |
| State EPCRA Rules or Laws: | Yes |
| Other (Specify): | |

# Executive Summary

Accidental Release Prevention and Emergency Response

Flavor Right Foods Group, Inc. desires to operate its ammonia refrigeration system without negative incidents that will affect its operation and surrounding community. The company will achieve this by ensuring the system design is by relevant standards and codes, and operated and maintained by competent service professionals or company personnel.

To help prevent and mitigate the results of negative incidents Flavor Right implemented results of mechanical integrity studies, process hazard analysis, local fire department involvement, and installation by a licensed contractor. However, the Flavor Right site incorporated specific emergency response actions into emergency action plans to account for the ammonia refrigeration system. The company referenced the International Institute of Ammonia Refrigeration (IIAR) and Occupational Safety and Health Administration (OSHA) for developing actions in case of a negative incident, and documented emergency response actions on the exterior of the ammonia refrigeration building, within the process safety management program, and within emergency response checklists.

Facility Description and Regulated Substances Used

Flavor Right Foods Group, Inc. occupies a warehouse type building for cold storage. The company stores concentrates and flavorings for desert fillings and toppings. Flavor Right uses an ammonia refrigeration system to maintain a cold dock, cooler, and freezer for receiving, storing, and shipping the food products.

The ammonia refrigeration system operates with approximately 13,500 pounds of ammonia, anhydrous. If a system operates at greater than 10,000 pounds, a company is responsible for developing a Process Safety Management program under OSHA and a Risk Management Plan (RMP) under the Environmental Protection Agency (EPA). These programs and plans help a company manage their risk of exposure to internal employees and the community.

The ammonia refrigeration system is a closed system and does not consume or emit ammonia. The process is such that the ammonia simply changes physical state between a gas and liquid to effectively cool spaces. There are not air emissions or water discharges from the process if the system when the system is operated and maintained appropriately.

General Release Prevention Program

The ammonia refrigeration system received updates in accordance with current codes and standards in 2010. The local fire department conducted several inspections during the 2010 update process to ensure the company engineered appropriate safeguards into the system. A professional engineer specializing in ammonia refrigeration systems completed a complete mechanical integrity study on the ammonia refrigeration system.

New instrumentation controls and monitors the ammonia refrigeration system. The company updated the ammonia refrigeration system with ammonia detection systems, including visual/audible alarms. All equipment pressure-relief valves are new installed 2010. The company utilizes a continuous flow ventilation fan. Emergency exhaust ventilation is available for emergency events.

Process equipment operates within design limits and is in good clean condition. There is not excessive dirt, scale, or ice built up around the system. The company secured equipment so it does not exhibit excessive vibration.

Administrative controls such as a Process Safety Management Program and Operating Procedures are in place to help prevent and mitigate releases. OSHA defines required Process Safety Management information and includes items like:
Â¿ Gathering and communicating process chemical information
Â¿ Documenting process technology information
Â¿ Documenting process equipment information
Â¿ Conducting process hazard analysis
Â¿ Ensuring and maintaining mechanical integrity of the system
Â¿ Developing and following operating procedures
Â¿ Conducting pre-startup review
Â¿ Process change management

Â¿ Compliance audits
Â¿ Hot work
Â¿ Training with proven competence

Five-Year Accident History

The previous owner of the ammonia refrigeration system experienced a negative incident requiring the local fire department to respond. The Flavor Right is not aware of additional factual data regarding the incident.

Flavor Right made significant improvements to the ammonia refrigeration system. The company has no incidents to report since they assumed ownership.

Elements of the Emergency Response Program

The key elements to the company's emergency response program are:
Â¿ Emergency instructions, phone numbers, and direct contacts posted on the exterior of the ammonia refrigeration building.
Â¿ Emergency Phone List incorporated into the PSM program listing Flavor Right emergency contacts, service contractor contacts, utility contacts, and local hospitals and occupational healthcare centers.
Â¿ Emergency Response Checklists describing evacuation and dealing with several common emergency events.
Â¿ The company designed the ammonia refrigeration system to shut down in the event that the ammonia detection system activates, and the system will activate emergency exhaust, and notify the local fire department.

Planned Changes to Improve Safety

Flavor Right implemented several upgrades to the ammonia refrigeration system in 2010. The company implemented critical findings discovered during the mechanical integrity study and process hazard analysis. Flavor right will continue to consider and/or implement additional findings to improve the safety of the ammonia refrigeration system.